

13/11/12

Work Order ID 53668

November 12, 2009 8:09:58 AM

PRELIMINARY ISSUE

Item ID: D4011-3

Revision ID:

Item Name: Clamp, Long

Start Date: 11/12/09 Start Qty: 2.00

Required Date: 11/16/09 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B-PRELIM

100



Purchasing

Purchasing

Memo

Issue PO:

Manufacture as per Dwg D4011

Supplier: G.F.I.

Material release note is required

0.00

0.00

PRE
Lim

12 9-11-12

6

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

QC2

Memo

0.00

0.00

12 9-11-12

120



QC

Quality Control

QC6 Inspect dimensions to drawing

QC8

Memo

0.00

0.00

2x

SP 09/11/12 2

- form as per dwg

- QC5

09.11.12

2x

Work Order ID 53668

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Page 2

Item ID: D4011-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp, Long

Start Date: 11/12/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Engineering

18 09.11.12

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BL09-11-27 (2)
R06324A NOV

POSITIVE RECALL

EFFECTIVE 08.11.12 AUTH W

RELEASED _____ DATE _____

Picklist Print

November 12, 2009 8:09:58 AM

Page 1

Work Order ID: 53668

Parent Item: D4011-3

Parent Item Name: Clamp, Long

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
dwg chg Prelim-B 09.11.12 DD verified by:EC

IPP RevB:

Start Date: 11/12/09

Required Date: 11/16/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	26.3521	0.1345	4.		



304SS sheet .080



189-11-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

26.3521

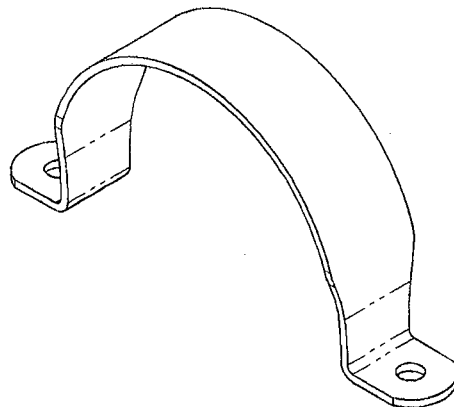
110993Q

26.3521

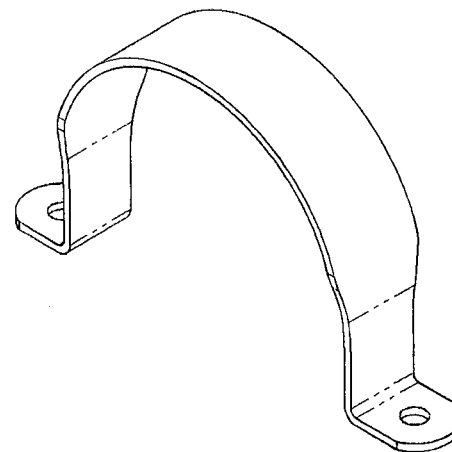
110993

①

also 53668



D4011-1 CLAMP, SHORT



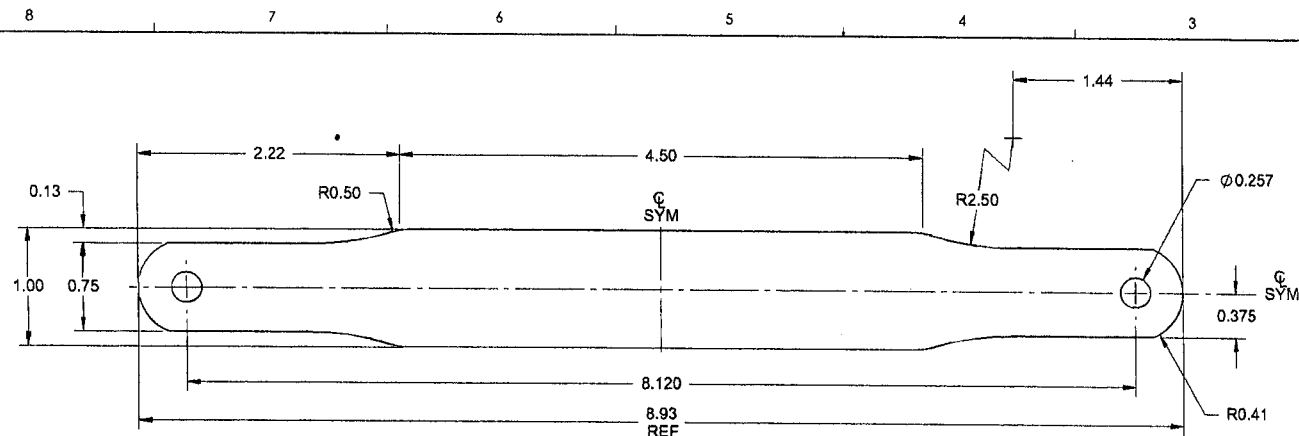
D4011-3 CLAMP, LONG

PRELIMINARY ISSUE

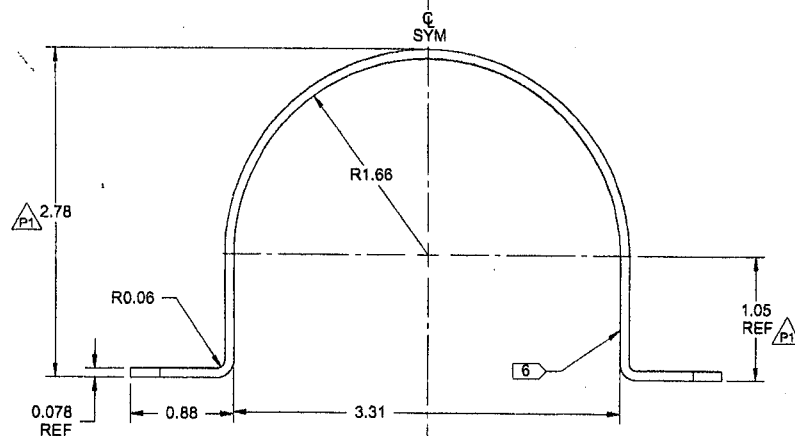
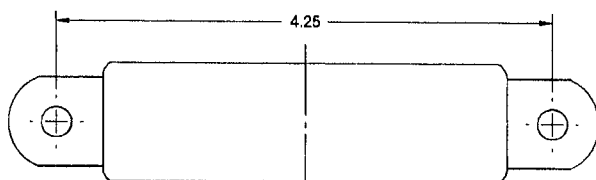
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

P1	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKID TUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. P1
MFG. APPR.		D4011	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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D4011-3F CLAMP FLAT PATTERN, LONG



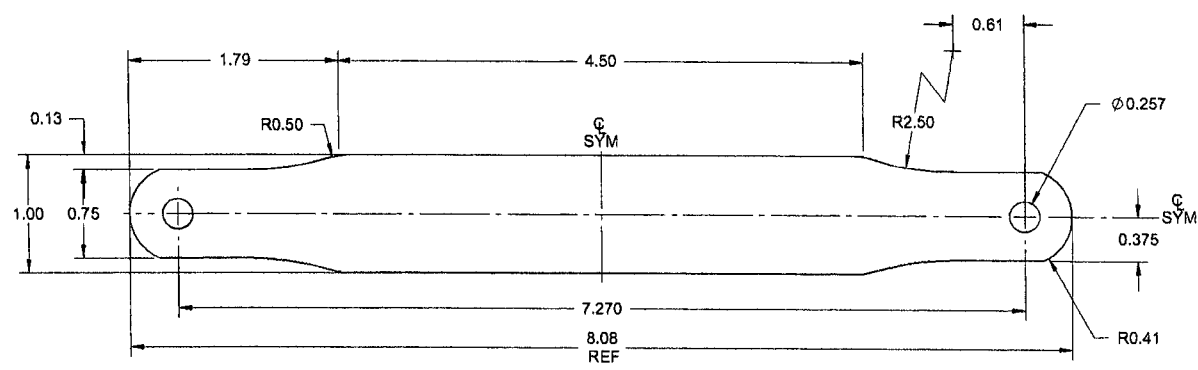
D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

PRELIMINARY ISSUE

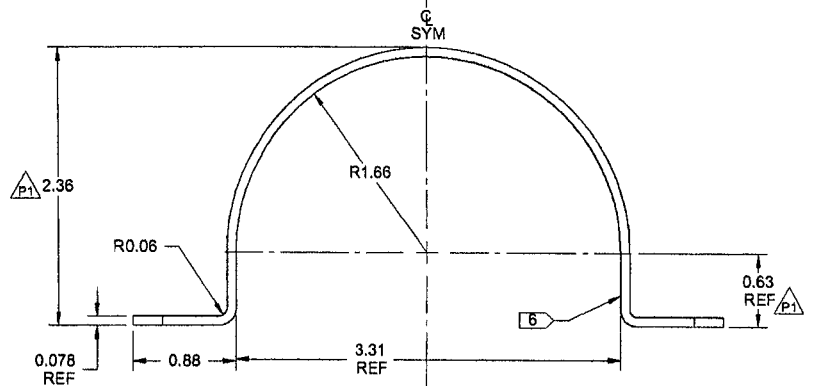
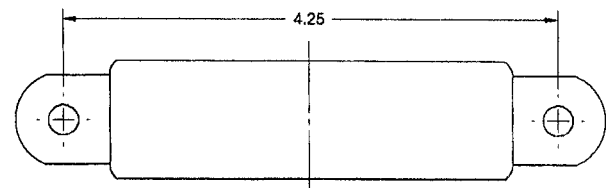
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53668



D4011-1F CLAMP, SHORT FLAT PATTERN



D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

PRELIMINARY ISSUE

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8 7 6 5 4 3 2 1

L Lacelle

From: David Duval [dduval@dartaero.com]

Sent: November 12, 2009 7:53 AM

To: Linda Lacelle

Subject: issue w/o please

- D4011-1 Clamp, Short, qty. = 3
- D4011-3 Clamp, Long, qty. = 2

David Duval

Production Engineering Coordinator

DART AEROSPACE LTD.

Tel: 1-613-632-5200

dduval@dartaero.com

www.dartaero.com